

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024770**Date Inspected:** 09-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BW

PCMK: SA3139B-001

Weld No: 001,002

Welder: 066881

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139B-002

Weld No: 001,002

Welder: 066881

WPS-B-T-2231-ESAB

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Components; OBG 13BW

PCMK: SA3139A-001

Weld No: 003,004

Welder: 066881

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139A-002

Weld No: 003,004

Welder: 066881

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139D-001

Weld No: 005,006

Welder: 066673

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139D-002

Weld No: 005,006

Welder: 066673

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139C-001

Weld No: 007,008

Welder: 066673

WPS-B-T-2231-ESAB

Components; OBG 13BW

PCMK: SA3139D-002

Weld No: 007,008

Welder: 066673

WPS-B-T-2231-ESAB

This Quality Assurance (QA) inspector performed Visual Testing (VT) of an area that has been previously tested by American Bridge Flour (ABF) QA personnel using the Magnetic Particle (MT) and VT method. This QA Inspector provided a turnover to dayshift personal for tracking of these welds. The member was identified as OBG 13W. The weld designations reviewed are as follows: (see photos below)

SEG3013D-004,009,014,019,024,029,034,039,044,049,054,059,064,069,074,202,203,208,209,210,211

SEG3013B-006,012,018,024,030,036,042

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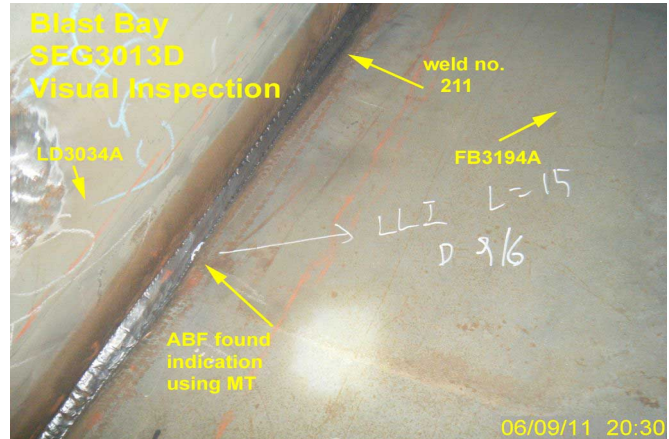
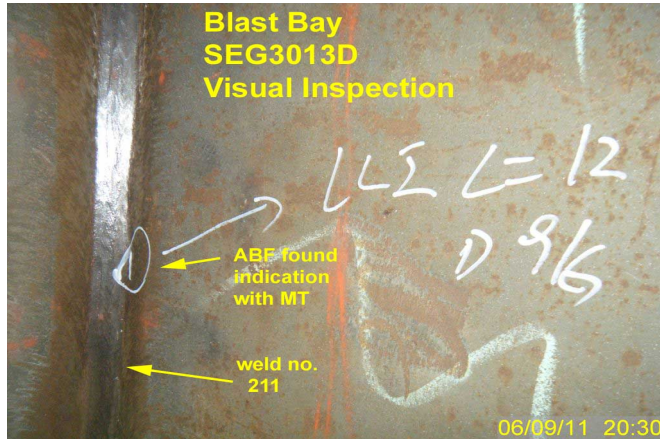
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This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 13W. The weld designations reviewed are as follows:

SEG3013D-004,009,014,019,024,029,034,039,044,049,054,059,064,069,074,202,203,208,209,210,211

SEG3013B-006,012,018,024,030,036,042

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer